

Date: Thursday, 9/21/2006 3:18:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 SKIDTUBE
Job Number	: 28686		
Estimate Number	: 10465		
P.O. Number	: <i>N/A</i>	Part Number	: D058672011
This Issue	: 9/21/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28657	Drawing Revision	: N/A
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/10/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev: F 02.06.24 Re-format; CHG002 (MPP2251); ECN 258 K J		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-011 CHG002

02.09.22 KJ

2.0	28686A	OH-58 SKIDTUBE ASSEMBLY
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Comment: Sub-Component OH-58 SKIDTUBE ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2652	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch =

✓ 24 D2652

Bushing

B27832

5.0	D2659	Lug Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2659

Lug Assembly

B28254

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: OH-58 SKIDTUBE

Job Number: 28686

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 10 D2712

Set Screw

B26746

7.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2935

Saddle Spacer

B28265-

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2934

Saddle Spacer

28264-

9.0

D29331

206 Saddle Left



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2933-1

Saddle

B27411 - B28669

10.0

D29321

206 Saddle Left side



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2932-1

Saddle

B28262-

11.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 1 D2968-043

Tow Ring

B28268-

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 SKIDTUBE

Job Number: 28686

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch =

✓ 4 AN3-37A Bolt

M1478 -

13.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN3-41A Bolt

M102171 -

14.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-6A Bolt

M101418 -

15.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN5-10A Bolt

M101271

16.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN5-12A Bolt

M101069 -

17.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN960JD10 Washer

M100743 =

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 28686

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 24 AN960JD416 Washer M102339

19.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN960JD516 Washer M102308-

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 1 AN970-4 Washer M100107-

21.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 MS21042L3 Nut (or -3) M101390

22.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)


Pick: Packing Kit

Qty Part Number Description Batch

✓ 13 MS21042L4 Nut (or -4) M19099-

Ref. 1310

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/11/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 28686

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2306/10/31 ①

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-672-011

Location:

REV A

2306/10/31

①

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2306/11/01

Job Completion



U 26-11-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Thursday, 9/21/2006 3:18:47 PM
Kim Johnston

Process Sheet

Part Number	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 SKIDTUBE ASSEMBLY
Part Number	: 28686A	Part Number	: D058672041
Estimate Number	: 10475	Drawing Number	: D2922 REV.A1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/21/2006 S.O. No. : N/A	Drawing Revision	: A1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LANDING GEAR	Due Date	: 10/10/2006 Qty: 1 Um: Each
Previous Run	: 28659A		
Written By	: <u>[Signature]</u>		
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev:C 02.06.28 Re-format; ECN 258 KJ Est Rev:D 06.02.06 Added Dt8025 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D058-672-041 CHG 001

N/A

2.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B28457 Pm' 06-10-10 (1)

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube Pm' 06-10-10 (1)

2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R Aluminum Rod

M101053/M101010 BE 06-10-10

3-Cut aft end of D2620 bent tube as per dwg D2922 Pm' 06-10-10 (1)

4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia. Pm' 06-10-10 (1)

5-Drill holes for wearplates using DT 8487 Open to 0.297" dia. Pm' 06-10-10 (1)

6-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit Pm' 06-10-10 (1)

8-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922 Pm' 06-10-10 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28686A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Deburr and Blow out all chips form inside the tube

pm'06-10-11 ①

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



pm'06-10-11 ①



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) -

Pick:

Qty Part Number Description

Batch

1 D2923 Web

B 28696 pm'06-10-13 ①

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid) *pm'06-10-11 ①*

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid) *pm'06-10-12 ①*

3-Deburr and Blow out all chips from inside the tube *pm'06-10-12 ①*

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R Sikaflex-291

Sikaflex expire date: *06-10-13*

m16193

pm'06-10-13 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-10-14

8.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number Description

Batch

1 D2794

Fwd Cap

B 14400 BE 06-10-10

W/O: 2		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28686A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 D2649

Crossbolt spacer

B28250 BE 06-10-16

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922.(Remember to back drill each hole to 0.250" before welding the other side)

A/R

Aluminum Rod

m10/10 BE 06-10-16

3-Grind welds flush as per Dwg D2922

pm 06-10-17

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

pm 06-10-17

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-10-17

PD 06-10-17

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/10/24

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06/10/25

14.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad

B27169

a.m 06/10/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28686A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-15 Wearshoe

B24845

16.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-21 Wearshoe

B27075

17.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2924 Wearshoe

B12425

18.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 MS27039-1-08 Screw

M100854

19.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 AN960JD10L Washer

M100233

a.m 06/10/25

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28686A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch
50 ALS4-1032-130 Insert *m 18990*
or (see QSI 017)

21.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
20 D2651-1 Plugs *B 28400*

22.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
20 D2651-3 O-Rings *B 25866*

23.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap *B 28041*

24.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS27039-1-08 Screw *M120854*

a.m 06/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/11/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 28686A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer *m100233*

a.m 04/10/25 ①

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

Sikaflex expire date: *02/07*

m102107

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: *02/07*

m102107

a.m

06/10/25 ①

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

102048

FC

06

Batch:

10 26 ①

27.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

Job 10-27 ①

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A.

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/01

Job Completion



W 06/10/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
A1	# CP 01.08.20	Ø0.640 WAS Ø0.625	

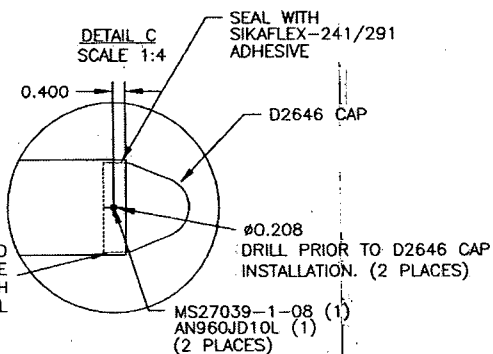
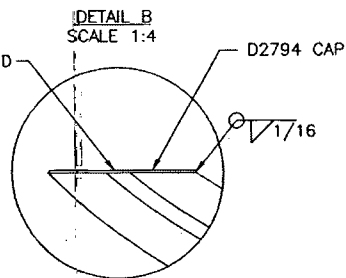
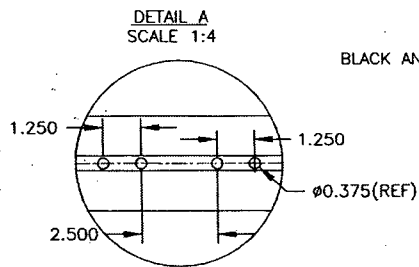
RELEASED
00.05.11 [Signature]

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

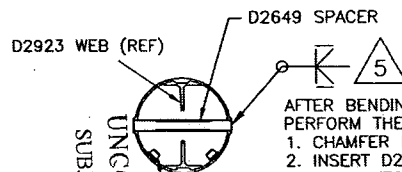
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART-QSI-015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

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WORK ORDER
NO. 28686A



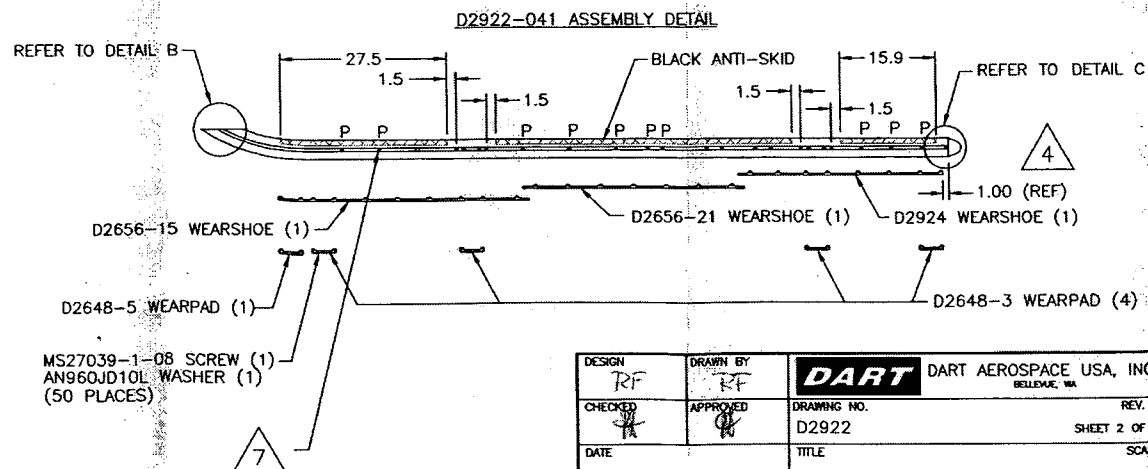
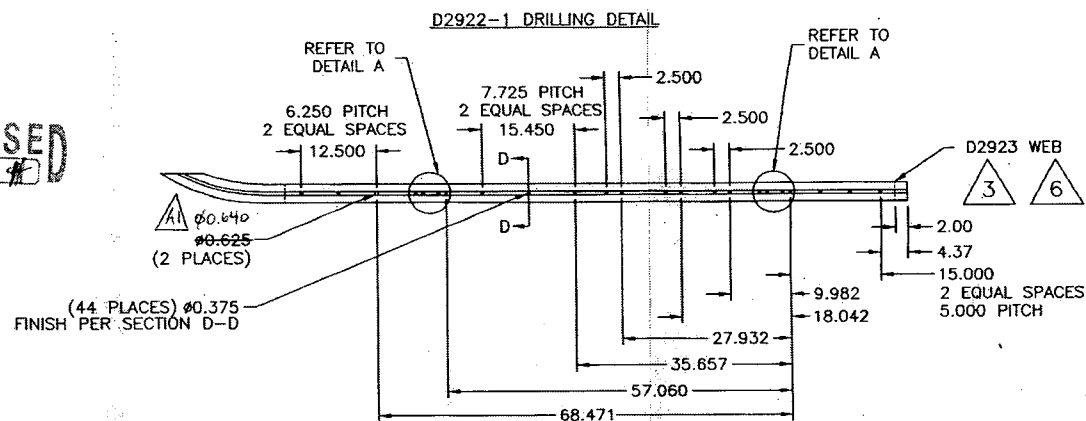
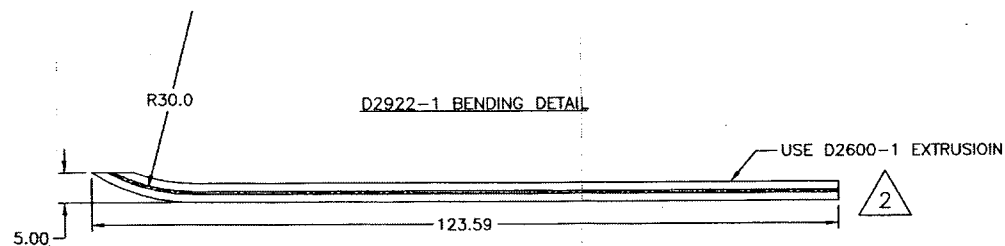
SECTION D-D
SCALE 1:4
FOR 0.375 HOLES ONLY



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER (22 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2649 SPACER TO 0.313 X 0.75 DEEP

AKS7-1032-130 (REF)
(50 PLACES)

RELEASED
00.05.11



DESIGN RF	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLEVUE, WA	REV. A
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	SHEET 2 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE 1:20

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NO. 35

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure TIG
Part number and Job number DO58672041 1/B 28687 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	1G <input checked="" type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into _____ Skidtube _____

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/16

Qualifier David Arnold